

Page 1

April 21, 2010 12:56:54 PM Item ID: D3696-041 Accept Setup Start **Revision ID:** Item Name: Arm Assembly Stop **Start Date:** 21/04/2010 Start Qty: 4.00 **Cust Item ID: Required Date: 28/04/2010** Req'd Qty: 4.00 **Customer:** Reference: Run Start Date 10-4-21 **Approvals:** Process Plan: Tooling: Date: Stop QC: Date: SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Draw Draw Plan Reject Accept Reject Work Center ID Description **Run Hours** Number Rev. Code Qty Qty Number **Draw Nbr Revision Nbr** D3696 Rev C 100 0.00 BAND SAW Bandsaw 0.00 Memo Jeaspa Bandsaw Cut blank 17.600" long

110

HAAS CNC vertical machine #1

HAAS 1

CONVENTIONAL MILLING MACHINE

Memo MILL AS PER DWG AND FOLIO FA918

DWG REV: FOLIO REV:

**DEBURR** 

0.00

0.00

Insp.

Stamp

# Dart Aerospace Ltd

W/O:		i e	W	ORK ORDER CHANG	ES				
DATE	STEP	PROC	EDURE CH	ANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
	-				:				
· · · · · · · · · · · · · · · · · · ·		i							
Part No	:	PAR #:	Fault Cat	egory:	NCR: Yes	No <b>DQ</b>	A:	Date: _	
		esolution:							
NCR:		W	ORK ORE	DER NON-CONFORMA	ANCE (NC	R)			
D.4.T.F.	0.750	Description of NC		Corrective Action Sect	ion B	Verifi	cation	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign Dat	&   Sect	ion C	Chief Eng	QC Inspector
,						ļ			
				ž.					
		. 1975-4-20					FAIA		
NOTE	oto 8 initi	al all entries							<u>.</u>
HUIE. U	ale a milli	ai aii enines							

April 21, 2010 12:56:54 PM



Page 2

Item ID:

D3696-041

Accept

Setup Start

Stop



Revision ID:

Item Name: Arm Assembly

**Start Date:** 

21/04/2010

Start Qty: 4.00

**Required Date: 28/04/2010** Req'd Qty: 4.00



**Cust Item ID:** 

**Customer:** 

Reference:

Approvals:

Process Plan: \_\_\_\_\_ Date: \_\_\_\_

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/ Work Center ID

120

QC

Quality Control

**Operation** Description

QC2- Inspect parts off machine FAI/FAIB

Set Up/ **Run Hours** 

0.00

0.00

Number

Draw

Draw Plan Rev. Code

Accept Qty

Reject Qty

Reject Insp. Number Stamp

130



QC8- Inspect parts - second check

Memo

Memo

0.00

0.00

Quality Control

Chemical Conversion Coat per QSI005 4.1

140

HandFinish

Hand Finishing

## **Dart Aerospace Ltd**

W/O:			V	VORK ORDER CHAI	NGES				1
DATE	STEP	PROCI	EDURE CH	IANGE		Ву	Date Qt	Approval Chief Eng / Prod Mgr	Approval QC Inspector
		1							
				•					
. ••									
Part No	):	PAR #:	Fault Ca	tegory:	NC	R: Yes	No DQA: _	Date: _	
.*	R	esolution:	Disposit	ion:	QA	: N/C CI	osed:	Date: _	
NCR:	odsia b	WC	ORK OR	DER NON-CONFOR	MANCE	(NCR	),,,,,		
DATE	STEP	Description of NC	la iti al		Section B	Ciam 0	Verificatio	n Approval	Approval
,		Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Date	Section C	Chief Eng	QC Inspector
			a a ga						
,			. <del></del>			1			
		The state of the s							
								_	
		in fragish				i			
		The Home of page							
NOTE: D	ate & initi	al, all entries	,						
H:\fFORMS	\Quality Ass	vrance\approved QA\NCRWO RevE							
						•			

April 21, 2010 12:56:54 PM



Page 3

Item ID:

D3696-041

Accept

Setup Start

Stop



**Revision ID:** 

Item Name: **Start Date:** 

Arm Assembly

21/04/2010

Start Otv: 4.00

**Required Date: 28/04/2010** Rea'd Otv: 4.00



Cust Item ID:

Customer:

Reference:

А	nn	ro	va.	6:

Process Plan: Date:

Tooling:

Set Up/

Run Hours

Date:

Date:

Rev.

Run

Start

Stop



QC: Date:

**SPC (Y/N):** 

Draw

Number

Plan Draw

Code

Accept Reject **Qty** 

Reject Number

Insp. Stamp

Sequence ID/ Work Center ID

150



Powdercoat Powder Coating Operation Description

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

M112588

0.00

0.00

=> M 10/05/01 4 B

Oty

Memo

1- mask prior to painting as per dwg (see note 8) START TIME: 2450 OVEN TEMPERATURE: 3750 GINISH

160



**Quality Control** 

QC3- Inspect Part Finish

0.00

0.00 27 m f 10/05/05



170



Small Fab Small Fab

Small Fab

Memo

Memo

0.00

0.00

1-Install Helicoil□2-Press Bushing □3-Install Plunger

7m/ 10/05/11



<b>Dart Aero</b>	space	Ltd
------------------	-------	-----

	•									
W/O:		i		WO	RK ORDER CHANGE	S			···	1 1
DATE	STEP	1 .	PR	OCEDURE CHAN	IGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
		1 1 1								
		1 1					,			
		1		A			······································			
Part No	:	i	PAR #:	Fault Categ	ory:	NCR: Yes	No <b>DQ</b>	<b>A</b> :	_ Date: _	<del> </del>
	Re	solution: _		Disposition	:	QA: N/C CI	osed:		Date:	
NCR:		1	,	WORK ORDE	R NON-CONFORMA	NCE (NCR	)			
DATE	STEP	Des	cription of NC		Corrective Action Section		Verific	cation	Approvai	Approval
	OIL.	i	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date		on C	Chief Eng	QC Inspector
		i i	سم							
		l			•					
							,			
										-
										;

NOTE: Date & initial all entries

April 21, 2010 12:56:54 PM



Page 4

Item ID:

D3696-041

Accept



Setup Start



**Revision ID:** 

Item Name: Arm Assembly

**Required Date: 28/04/2010** 

**Start Date:** 

21/04/2010

Start Qty: 4.00

Req'd Qty: 4.00



**Cust Item ID:** 

**Customer:** 

Draw

Number

Reference:

Approvals:

Process Plan: \_\_\_\_\_ Date: \_\_\_\_

Tooling:

Date:

Draw

Rev.

Run

Start

Stop

Stop



Date:\_\_\_\_\_

SPC (Y/N):

Date:

Reject

Insp.

Sequence ID/ Work Center ID

180

Quality Control

Operation Description

QC5- Inspect part completeness to step on W/O

Set Up/ **Run Hours** 

Code

Plan

Accept Qty

Reject Qty

Number Stamp

190

Packaging Packaging

Identify as per dwg & Stock Location:

Memo

Memo

0.00

0.00

200

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

DATE STEP PROCEDURE CHANGE By Date Qty Approval Chief Eng / QC Insp Col Insp Prod Mgr Prod Mg	
	val ector
Resolution: Disposition: OA: N/C Clased: Date:	
Disposition Disposition QA. N/C Closed: Date:	<b>—</b> ,
NCR: WORK ORDER NON-CONFORMANCE (NCR)	
DATE STEP Description of NC Corrective Action Section B  Unitial Action Description Section B  Verification Approval Approval	val
Section A Initial Action Description Sign & Section C Chief Eng Ch	

NOTE: Date & initial all entries

Parent Item:

D3696-041

Parent Item Name:

Arm Assembly

**Comments:** 

IPP Rev:A New Issue 08-05-01 JLM

Verified By:EC IPP Rev:B 08-07-22 redesign part (prelim) DD verified by:EC

Manufactured

No

**Start Date: 21/04/2010** 

Required Date: 28/04/2010

Start Qty: 4.00

Required Oty: 4.00

REV:C NOW ON CNC MILL 10-03-17 JLM VERIFIED BY:DD Component Item ID/ Replacement Mfg/ Bin Primary Last Route Unit of Qty on Remaining Qty Date Status M7075T6B1.000X1.000 Purchased No 100 f 12.0000 6.1231 7075 T6 BAR 1.00 x1.00 Warehouse Loc Oty Loc Code Location Main Warehouse MAT 12 114415 12 D3799-1 Manufactured No 170 Each 52.0000 4.0000

Oilite Bronze Bushing

D3801-3

Warehouse Loc Qty Loc Code Location

Main Warehouse

ST088

52

52 170 Each

16.0000 4.0000

Hand Retractable Spring Plunger

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST088

55571

16

16

4K M/2 b/05/0

## **Dart Aerospace Ltd**

Apr.	-								
W/O:		** U	WO	RK ORDER CHANG	ES				*
DATE	STEP	PRO	OCEDURE CHAP	IGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
	;								
· · · · · · · · · · · · · · · · · · ·							ļ		
									1
Part No	•	PAR #:	Fault Categ	ory:	_ NCR: Yes	No <b>DQ</b>	A:	Date: _	
	Re	esolution:	Disposition	:	QA: N/C Closed: Date:				
NCR:			WORK ORDE	R NON-CONFORM	ANCE (NCR	3)			
DATE	STEP	Description of NC	<u> </u>		ion B	Verific	cation	Approval	Approval
	JOIL!	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Secti	ion C	Chief Eng	QC Inspector
,									
		,							
							-		
	1 1		ı l		i	I		1	1

NOTE: Date & initial all entries

#### Picklist Print

April 21, 2010 12:56:58 PM

Page 2

Work Order ID: 58010

Parent Item:

D3696-041

Parent Item Name:

Arm Assembly

Comments:

IPP Rev:A New Issue 08-05-01 JLM Verified By:EC

IPP Rev:B 08-07-22 redesign part (prelim) DD verified by:EC

REV:C NOW ON CNC MILL 10-03-17 JLM VERIFIED BY:DD

**Start Date: 21/04/2010** 

Otv

Required Date: 28/04/2010

Start Oty: 4.00

Required Otv: 4.00

Component Item ID/ MS21209C8-20

Replacement Mfg/

Purchased

Bin Primary

No

Last

Route 170

Unit of Each

Qty on

Remaining

153.0000 4.0000

Date

Status

Heli Coil Insert

Warehouse

Loc Oty

Loc Code

Location

Main Warehouse

ST305

153

153

4x m-k w/os/u

W/O:			W	ORK ORDER CHAN	GES			-		
DATE	STEP	PRO	OCEDURE CH	ANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No		PAR #:								
	Re	esolution:	Disposition	on:	QA:	N/C Clo	sed:		Date:	
NCR:		•	WORK ORD	ER NON-CONFORM	MANCE	(NCR	)			
DATE	STEP	Description of NC Section A	Initial	Corrective Action Se Action Description	ection B	Sign &	I	cation on C	Approval Chief Eng	Approval QC Inspector
		occiton //	Chief Eng	Chief Eng		Date	3601	On C	Officer Eng	QC Inspector
									,	
		144.44								
NOTE: D	ate & initia	ıl all entries								

H:\fFORMS\Quality Assurance\approved QA\NCRWO RevE

DART AEROSPACE LTD	Work Order:	58010
Description: Arm	Part Number:	D3696-1
Inspection Dwg: D3696 Rev: C		Page 1 of 1

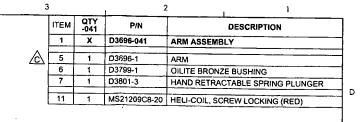
# FIRST ARTICLE INSPECTION CHECKLIST

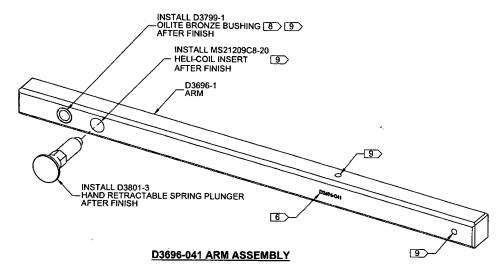
X First Article	Prototype
-----------------	-----------

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.203	+0.005/-0.001	.703			-	
Ø0.500 x 0.300 deep	+/-0.010	:200× 303		<del> </del>		
5.500	+/-0.010	5 493	V			
0.495	+/-0.010	499				
0.990	+/-0.010	989				
1.000	+/-0.010	.999				1
Ø0.566	+0.001/-0.000	567	<b>'</b> /			
0.500	+/-0.010	.497	1/			
1.800	+/-0.010	1 799				
1.250	+/-0.010	1.347				
17.50	+/-0.310	17 Rg	·/			
0.750	+/-0.010	745		_		
0.06 x 45°	+/-0.030 x 0.5°	.07~45°	-1//			
0.13 x 45°	+/-0.030 x 0.5°	13 ~ 450	J	<del></del>		
		******				
					7.00	
	·					

Measured by:	mv=	Audited by:	4.A	Prototype Approval:	N/A
Date:	10/04/29	Date:	10/04/29	Date:	N/A
		<u> </u>	<del></del>		

Rev	Date	Change	Revised by	Approved
Α	10.04.01	New Issue	KJ 🚧	





SHO<sub>b</sub> COLA RETURN TO ENGINEERING UNCONTROLLED COPY SUBJECT TO AMENDMENT WITHOUT NUTTICE WORK ORDER 5 500 B 10-4-21

С	REVISE Ø0.500 REASOI FEEDBA	D ITEM X 0.300 N: REUE ACK FRO	5 AS FO DP' WA SIGNED DM END	LLOWS: 'Ø0.201 THRU CBORE S 2 PL (ZN C4-2). O ARMREST CUSHION BASED ON USERS AT HAI 2009	мв	09.06.17
В	PRT-12 PROCU DRAWIN	(ZN C7- RED TH NGS: AD	1) - REA ROUGH IDED ØI	137 (ZN D6-1): PIN D3801-3 WAS SOS PURCHASED PARTS NOW D3799 AND D3801 SPEC CONTROL D3799 AND D3801 SPEC CONTROL D5-01 (ZN B5-2): 1.000 WAS 0.990 POCKETS REMOVED PWD-AFT ARMREST ADJUSTMENT	мв	08.07.17
Α	NEW ISSUE			мв	08.04.18	
REV.	DESCRIPTION			BY	DATE	
DESIG	١		ξ	DART AEROSPA	CFI	TD
DRAWN		¥ _	HAWKESBURY, ONTARIO, CANADA			
CHECK	ED	7	(1)5	DRAWING NO.		REV. C
MFG. APPR.		1.	D3696		SHEET 1 OF 2	
APPRO	VED	1/1	10	TITLE		SCALE
DE APPR.		#	ARM ASSEMBLY		NTS	
DATE 09.06.17			141	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT OF PRIVATE AND CONSTRUCTION, AND IS SUPPLED ON THE EXPRESS CONSTRUCT IS NOT TO BE USED FOR NAME HANDOOD ON COPIED ON COMMANDATE TO ANY OTHER PORSON WITHOUT		

D3696-041 NOTES:

1) MATERIAL: N/A

2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3

3) TOLERANCES: PER DART QSI 018 UNILESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED 5) BREAK SHARP EDGES:N/A

6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3696-041" USING FINE POINT PERMANENT INK MARKER LOCATED APPROXIMATELY AS SHOWN

7) WEIGHT: 1.69 lbs

D

8) FACE D3799-1 OILITE BRONZE BUSHING FLUSH TO D3696-1 ARM AS REQUIRED ON BOTH SIDES PRIOR TO POWDER COATING 9) MASK HOLES AS SHOWN PRIOR TO POWDER COATING

